

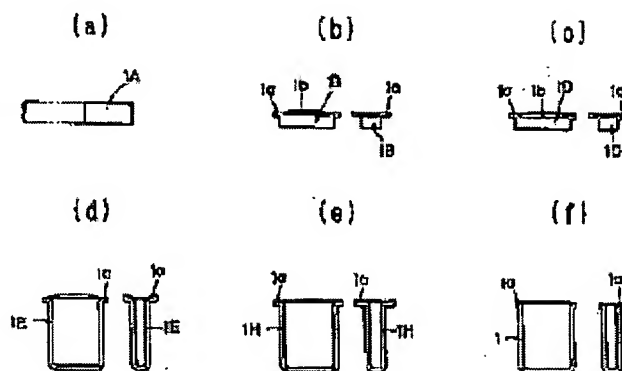
PRODUCTION OF PIEZOELECTRIC VIBRATOR CASE

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Abstract of JP9174167

PROBLEM TO BE SOLVED: To obtain a producing method of a case of a piezoelectric vibrator which improves the material yield and reduces the material cost to obtain the material from a circular cross section wire or a rod and which reduces the die cost by making a completed product with a comparatively easily producing die without including a composite die of elliptic sectional die in a small number of forming processes. **SOLUTION:** In a 1st process a, a circular cross-section wire or rod is sheared in a circular column body 1A having a prescribed length, in a 2nd process b, the circular column body is pressed from the axial right angle direction, a long width hexahedron-like 1B having a flange part 1a on the upper face is formed and it is annealed in 3rd process c. Next, in a 4th process d, an upper face central part having the flange part is pressurized, impact-formed without a rest into a bottomed cylinder body 1E having a cross-section almost oval-shaped flange, in a 5th process e, the flange part is pressurized, a right angle and flat face against the cylinder part is formed, and in a 6th process f, the circumferential periphery of the flange part is trimmed, and a piezoelectric vibrator case 1 is completed.



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